

# Work Order ID 70589

Monday, June 13, 2011 11:21:58 AM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*R*

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

*S 11/7/08*

*CK low CL 11/07/07*

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

\*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

*EP 11/07/08*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\*

*S 11/07/08*

*(+1)*

*44*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 70589**

Page 2

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br>                        | Pick Kit                                               | 0.00                 |         |        |              |               |               |                  |                |
| Packaging<br>                  | Memo                                                   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                        |                      |         |        |              |               |               |                  |                |
| 140<br>                        | QC4- 100% Inspect kits for completeness                | 0.00                 |         |        |              |               |               |                  |                |
| QC<br>                         | Memo                                                   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                        |                      |         |        |              |               |               |                  |                |
| 150<br>                        | Packaging                                              | 0.00                 |         |        |              |               |               |                  |                |
| Packaging<br>                  | Memo                                                   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Identify and pack for shipping as per PPP D412-630-031 |                      |         |        |              |               |               |                  |                |
|                                | Location: _____                                        |                      |         |        |              |               |               |                  |                |
|                                | PPP Rev: _____                                         |                      |         |        |              |               |               |                  |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 70589**

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 6/07/08

WF  
11-07-08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Monday, June 13, 2011 11:22:06 AM

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011


Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP REV. A 05.11.21 NEW ISSUE EC  
IPP REV. B 05.12.19 updated pick list EC  
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|                                                                                  |  |           |    |  |  |     |      |         |   |   |  |  |  |
|----------------------------------------------------------------------------------|--|-----------|----|--|--|-----|------|---------|---|---|--|--|--|
| AN310-4                                                                          |  | Purchased | No |  |  | 130 | Each | 35.0000 | 1 | 1 |  |  |  |
|  |  |           |    |  |  |     |      |         |   |   |  |  |  |
| NUT                                                                              |  |           |    |  |  |     |      |         |   |   |  |  |  |

Location Loc Qty Loc Code

ST324 35  
117795 15  
117872 20

|                                                                                  |  |           |    |  |  |     |      |         |   |   |  |  |  |
|----------------------------------------------------------------------------------|--|-----------|----|--|--|-----|------|---------|---|---|--|--|--|
| AN310-5                                                                          |  | Purchased | No |  |  | 130 | Each | 20.0000 | 2 | 2 |  |  |  |
|  |  |           |    |  |  |     |      |         |   |   |  |  |  |
| NUT                                                                              |  |           |    |  |  |     |      |         |   |   |  |  |  |

Location Loc Qty Loc Code

ST324 20  
114830 20

|                                                                                    |  |           |    |  |  |     |      |           |   |   |  |  |  |
|------------------------------------------------------------------------------------|--|-----------|----|--|--|-----|------|-----------|---|---|--|--|--|
| AN3C5A                                                                             |  | Purchased | No |  |  | 130 | Each | 1,757.000 | 3 | 3 |  |  |  |
|  |  |           |    |  |  |     |      |           |   |   |  |  |  |
| Bolt                                                                               |  |           |    |  |  |     |      |           |   |   |  |  |  |

Location Loc Qty Loc Code

FP-A 7  
115835 7  
ST350 1750  
116419 96  
116549 54  
117343 500  
117508 300  
117764 300  
117872 500

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 13, 2011 11:22:06 AM

Page 2

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN44-C12

Purchased

No

130

Each

23.0000

1



eyebolt

Location

Loc Qty

Loc Code

ST362

23

114669

3

117616

20

AN4C15

Purchased

No

130

Each

15.0000

1



BOLT

Location

Loc Qty

Loc Code

ST358

15

117764

15

AN5C11

Purchased

No

130

Each

33.0000

1



BOLT

Location

Loc Qty

Loc Code

ST337

33

113950

3

114801

30

AN5C15

Purchased

No

130

Each

27.0000

1



BOLT

Location

Loc Qty

Loc Code

ST338

27

114669

7

117616

20

AN960C10

NAS1149C0363  
R

Purchased

No

130

Each

0.0000

7



WASHER

1114742 11/7/88

Monday, June 13, 2011 11:22:06 AM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 11:22:06 AM

Page 3

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased No

130 Each

39.0000

1

1



WASHER



sh 11/10

Location

Loc Qty

Loc Code

ST347

39

102842

39

D3454-1

Manufactured No

130 Each

20.0000

1

1



Bushing



SD

Location

Loc Qty

Loc Code

ST054

20

58555

20

D3454-3

Manufactured No

130 Each

10.0000

2

2



Bushing



SD

Location

Loc Qty

Loc Code

ST058

10

56420

10

D3454-5

Manufactured No

130 Each

12.0000

2

2



Bushing



SD

Location

Loc Qty

Loc Code

ST054

12

68468

12

D3455-1

Manufactured No

130 Each

7.0000

4

4



Spacer



BZ0529 11/7/7.0

Location

Loc Qty

Loc Code

ST054

7

68469

7

Monday, June 13, 2011 11:22:07 AM

Shop Packet Print

Page 3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 11:22:07 AM

Page 4

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130 Each

21.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST054

21

68470

21

Manufactured No

130 Each

0.0000

1

1

D3462-041



Bracket Assembly

MS21043-3

Purchased No

130 Each

353.0000

3

3



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

273

112314

273

MS24665-227

Purchased No

130 Each

28.0000

2

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

28

113845

28

Purchased No

130 Each

123.0000

2

2

MS24665-229



COTTER PIN

Location

Loc Qty

Loc Code

ST309

123

111041

123

Monday, June 13, 2011 11:22:07 AM

Shop Packet Print

Page 4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Page 5

Work Order ID: 70589

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H5

Purchased

No

130

Each

123.0000

1

Washer

## Location

## Loc Qty

## Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

D3463-041

Manufactured

No

110

Each

0.0000

1

Step Weldment Assembly

D3443-043

Manufactured

No

110

Each

0.0000

1

Strut Weldment Assembly

D3443-041

Manufactured

No

110

Each

0.0000

1

Strut Weldment Assembly

D3443-9

Manufactured

No

110

Each

4.0000

2

Pin

## Location

## Loc Qty

## Loc Code

ST053

4

68475

4

D3454-7

Manufactured

No

110

Each

2.0000

2

Bushing

## Location

## Loc Qty

## Loc Code

ST054

2

59256

2

Monday, June 13, 2011 11:22:07 AM

Shop Packet Print

Page 5

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 13, 2011 11:22:07 AM

Page 6

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3453-1  
Spacer

Manufactured No

110 Each

7.0000

2

Location

Loc Qty

Loc Code

ST054

7

68469

7

110

Each

18.0000

1

D3465-1  
Washer

Manufactured No

Location

Loc Qty

Loc Code

ST054

18

46134

18

110

Each

21.0000

2

AN4CH3  
SS Bolt

Purchased No

Location

Loc Qty

Loc Code

ST355

1

114801

1

ST357

20

117616

20

110

Each

39.0000

1

AN4C14  
BOLT

Purchased No

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

14

114669

14

Monday, June 13, 2011 11:22:08 AM

Shop Packet Print

Page 6

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 11:22:08 AM

Page 7

Work Order ID: 70589

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-4

Purchased

No

110

Each

35.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

35

117795

15

117872

20



EP 11/07/07

M118078 (24)

AN310-7

Purchased

No

110

Each

41.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

41

114784

41



EP 11/07/07

MS24665-227

Purchased

No

110

Each

28.0000

1

1



COTTER PIN

Location

Loc Qty

Loc Code

ST309

28

113845

28



EP 11/07/07

~~M111041~~  
M111041 (12)

MS24665-302

Purchased

No

110

Each

204.0000

1

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

4

113644

4

ST357

200

117460

200



EP 11/07/07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

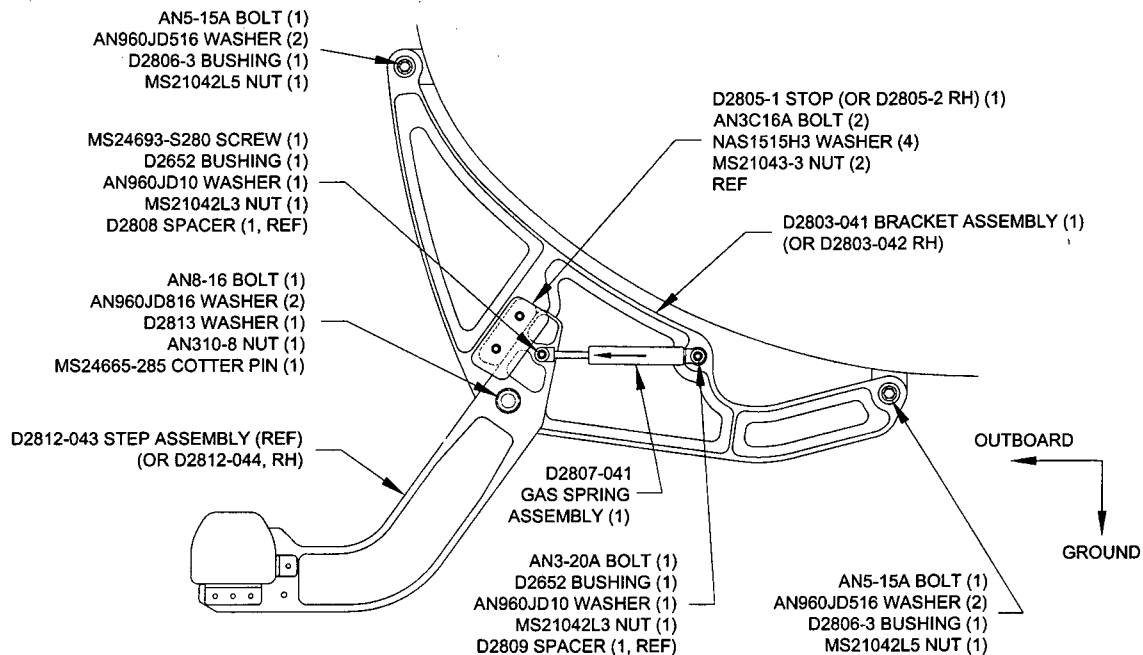
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

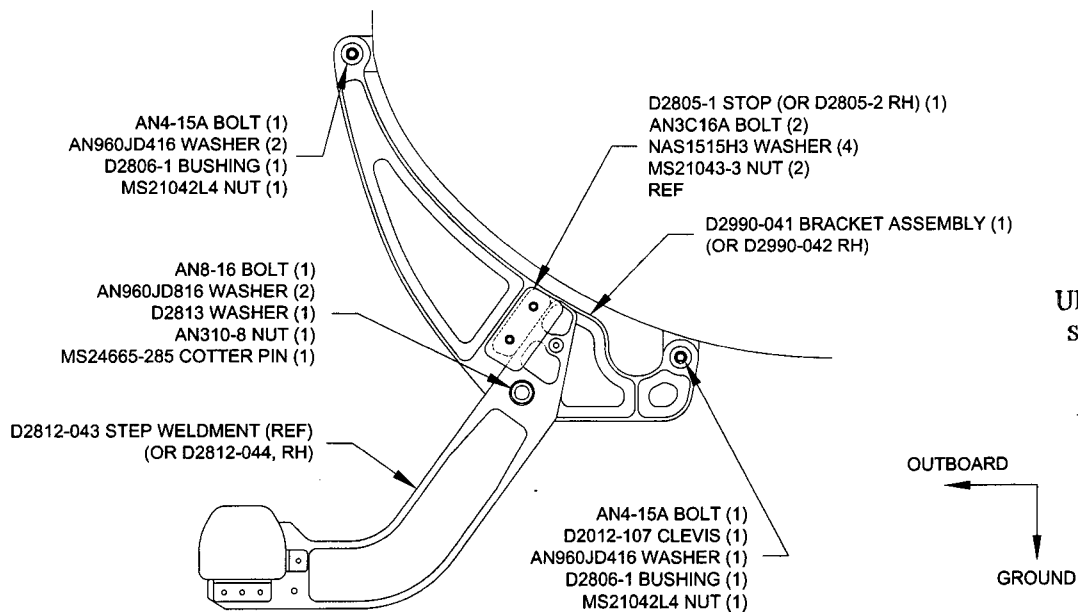
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**D412-630-011/-012 Heli-Access-Step™ Installation**



**FIGURE 4 – STA 84.29 for D412-630-011/-012 Heli-Access-Step™ Installation (View rotated 90° CW)**



**FIGURE 5 – STA 129.00 for D412-630-011/-012 Heli-Access-Step™ Installation (View rotated 90° CW)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70589

R1106-13

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Revision: M  
Date: 08.12.12

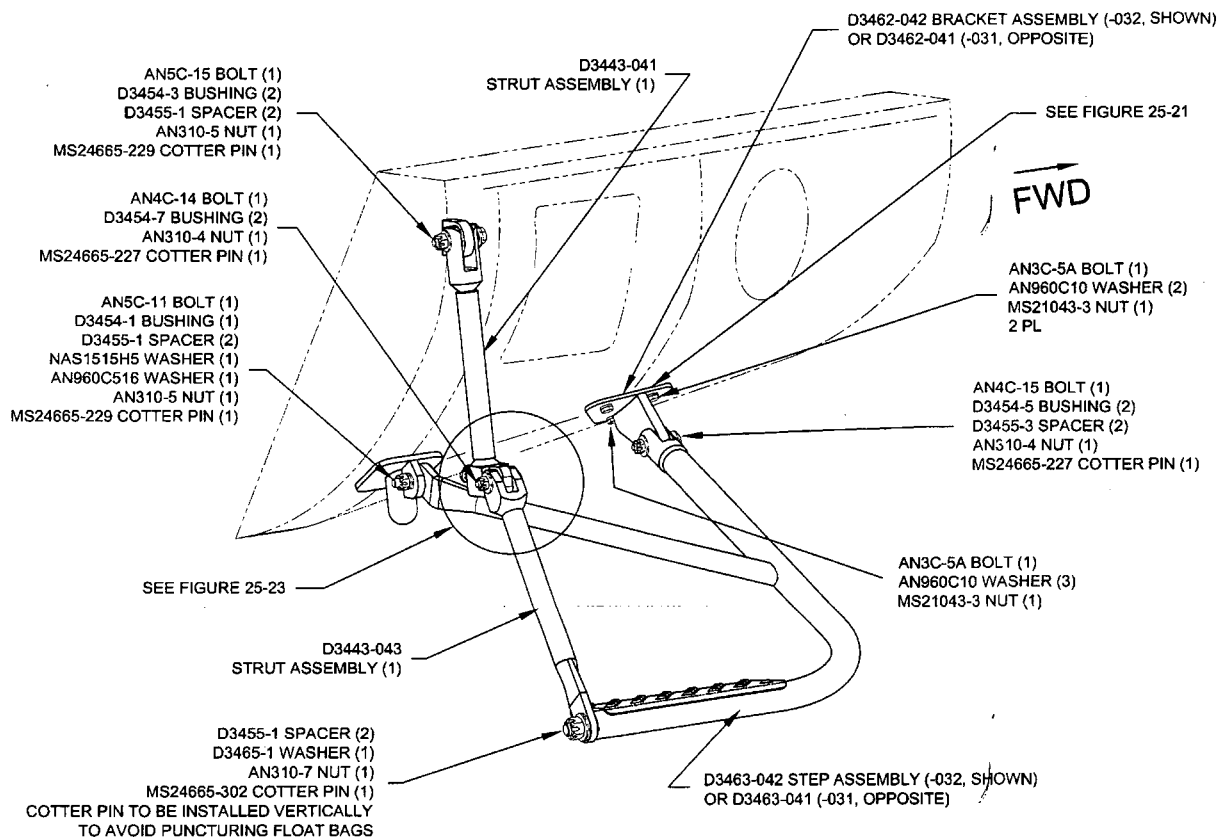
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

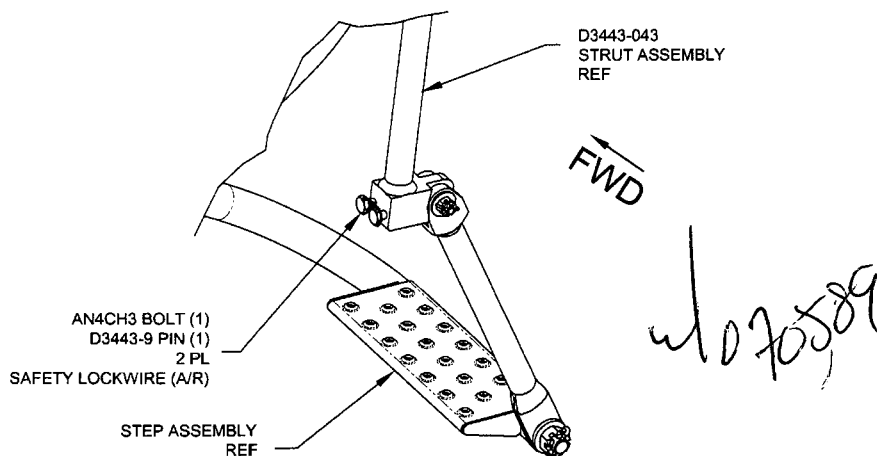
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**



**FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**

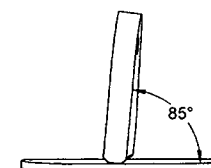
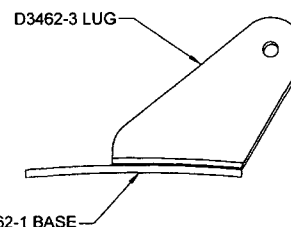
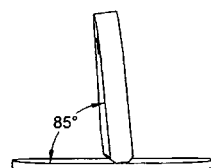
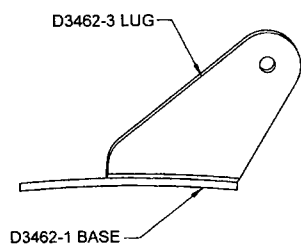
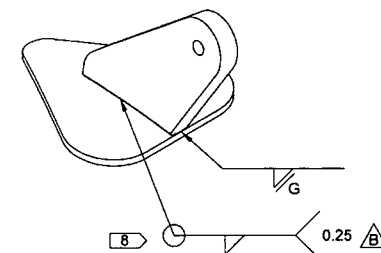
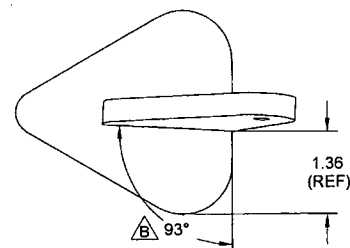
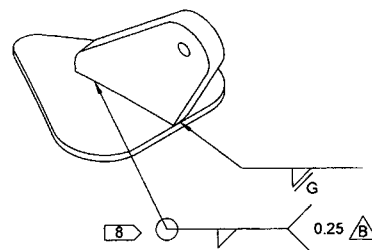
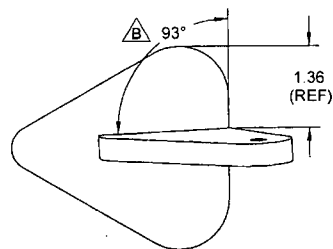
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**25-00-00**

| Qty<br>-031  | Qty<br>-032  | Part Number            | Description                       |
|--------------|--------------|------------------------|-----------------------------------|
| X            |              | D412-630-031           | PILOT/CO-PILOT STEP, LH (FOLDING) |
|              | X            | D412-630-032           | PILOT/CO-PILOT STEP, RH (FOLDING) |
| <del>1</del> | <del>1</del> | <del>D3443-041</del>   | <del>STRUT ASSEMBLY</del>         |
| <del>1</del> | <del>1</del> | <del>D3443-043</del>   | <del>STRUT ASSEMBLY</del>         |
| <del>2</del> | <del>2</del> | <del>D3443-9</del>     | <del>PIN</del>                    |
| 1            | 1            | D3454-1                | BUSHING                           |
| 2            | 2            | D3454-3                | BUSHING                           |
| 2            | 2            | D3454-5                | BUSHING                           |
| <del>2</del> | <del>2</del> | <del>D3454-7</del>     | <del>BUSHING</del>                |
| 6 (4)        | 6            | D3455-1                | SPACER                            |
| 2            | 2            | D3455-3                | SPACER                            |
| 1            |              | D3462-041              | BRACKET ASSEMBLY                  |
|              | 1            | D3462-042              | BRACKET ASSEMBLY                  |
| <del>1</del> |              | <del>D3463-041</del>   | <del>STEP ASSEMBLY</del>          |
|              | 1            | <del>D3463-042</del>   | <del>STEP ASSEMBLY</del>          |
| <del>1</del> | <del>1</del> | <del>D3465-1</del>     | <del>WASHER</del>                 |
| 2 (1)        | 2            | AN310-4                | NUT                               |
| 2            | 2            | AN310-5                | NUT                               |
| <del>1</del> | <del>1</del> | <del>AN310-7</del>     | <del>NUT</del>                    |
| 3            | 3            | AN3C-5A                | BOLT                              |
| 1            | 1            | AN44-C12               | * EYEBOLT                         |
| <del>1</del> | <del>1</del> | <del>AN4C14</del>      | <del>BOLT</del>                   |
| 1            | 1            | AN4C15                 | BOLT                              |
| <del>2</del> | <del>2</del> | <del>AN4CH3</del>      | <del>BOLT</del>                   |
| 1            | 1            | AN5C11                 | BOLT                              |
| 1            | 1            | AN5C15                 | BOLT                              |
| 7            | 7            | AN960C10               | WASHER                            |
| 1            | 1            | AN960C516              | WASHER                            |
| 3            | 3            | MS21043-3              | NUT                               |
| 2 (1)        | 2            | MS24665-227            | COTTER PIN                        |
| 2            | 2            | MS24665-229            | COTTER PIN                        |
| <del>1</del> | <del>1</del> | <del>MS24665-302</del> | <del>COTTER PIN</del>             |
| 1            | 1            | NAS1515H5              | WASHER                            |

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP





**REFERENCE ONLY**

**D3462-041 BRACKET ASSEMBLY**

**D3462-042 BRACKET ASSEMBLY**

| QTY<br>-041 | QTY<br>-042 | P/N       | DESCRIPTION      |
|-------------|-------------|-----------|------------------|
| X           |             | D3462-041 | BRACKET ASSEMBLY |
|             | X           | D3462-042 | BRACKET ASSEMBLY |
| 1           | 1           | D3462-1   | BASE             |
| 1           | 1           | D3462-3   | LUG              |

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

|            |                                                                                |    |          |
|------------|--------------------------------------------------------------------------------|----|----------|
| C          | SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG<br>REASON: PRODUCTION FACILITY | DC | 07.10.24 |
| B          | REVISE DIMENSIONS                                                              | RF | 05.12.05 |
| A          | NEW ISSUE                                                                      | RF | 05.09.20 |
| REV.       | DESCRIPTION                                                                    | BY | DATE     |
| DESIGN     |                                                                                |    |          |
| DRAWN      |                                                                                |    |          |
| CHECKED    |                                                                                |    |          |
| MFG. APPR. |                                                                                |    |          |
| APPROVED   |                                                                                |    |          |
| DE APPR.   |                                                                                |    |          |
| DATE       | 07.10.24                                                                       |    |          |

RELEASED  
06.07.07 1.7.20

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3462** REV. C  
SHEET 1 OF 2

TITLE **BRACKET ASSEMBLY** SCALE 1:2

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